

Work Order ID 110880

January-08-14 12:36:49 PM

110880

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Item ID: D3017-041 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Seat Back Stop *NS2*

Start Date: 1/08/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/08/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MCT Date: 14-01-09 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: 1121925 0.00

100 Large Fab

Memo 0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

14-01-09

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110 QC Memo 0.00

Quality Control

14-4-14 DAS 24 9-89

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
150	Identify as per dwg & Stock Location: <u>6A</u>	0.00								
150										
Packaging	Memo	0.00				<u>1x</u>			<u>14/04/23</u>	
Packaging										
160	QC21- Final Inspection - Work Order Release	0.00								
160										
QC	Memo	0.00							<u>MLJ 14-04-23</u>	
Quality Control										

MLJ 14-04-23

Picklist Print

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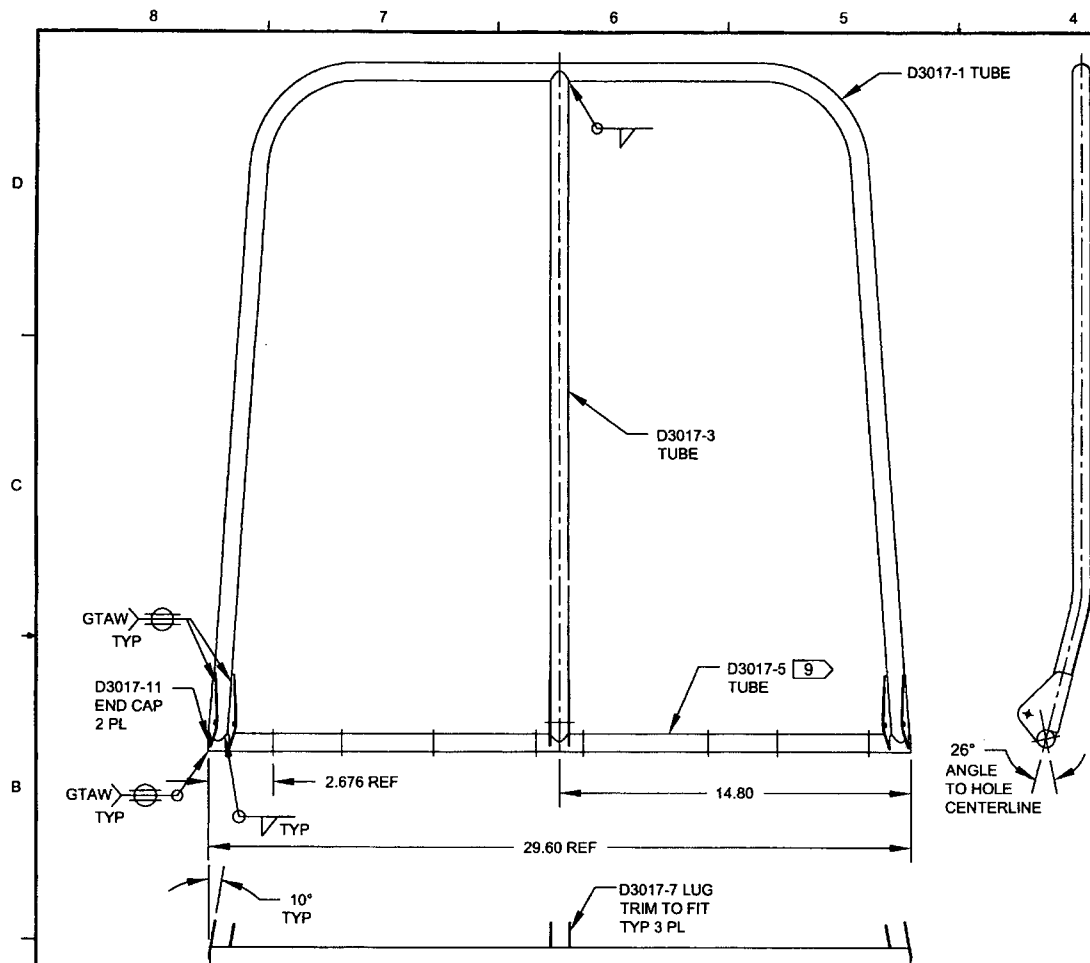
Work Order ID: 110880
Parent Item: D3017-041
Parent Item Name: Seat Back

Start Date: 1/08/14 Required Date: 1/08/14
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 4130 RD Tube .750 x.083W		Purchased	No			100	f	52.2100	2.458	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		52.21							
				m127493		32.54							
				m127866		19.67							
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	463.2000	11.125	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		112.5							
				m127866		112.5							
				MAT033		350.7							
				125313		165.7							
				m127111		185							
D3017-11 Cap		Manufactured	No			100	Each	36.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		36							
				104954		16							
				106668		15							
				107169		5							
D3017-7 Lug		Manufactured	No			100	Each	17.0000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		6							
				100996		6							
				WA002		11							
				105568		11							

111629x1



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

110880MLJ
14-01-09

RELEASED
2010-02-02
WJ

D3017-041 BACK FRAME ASSEMBLY

NOTES:

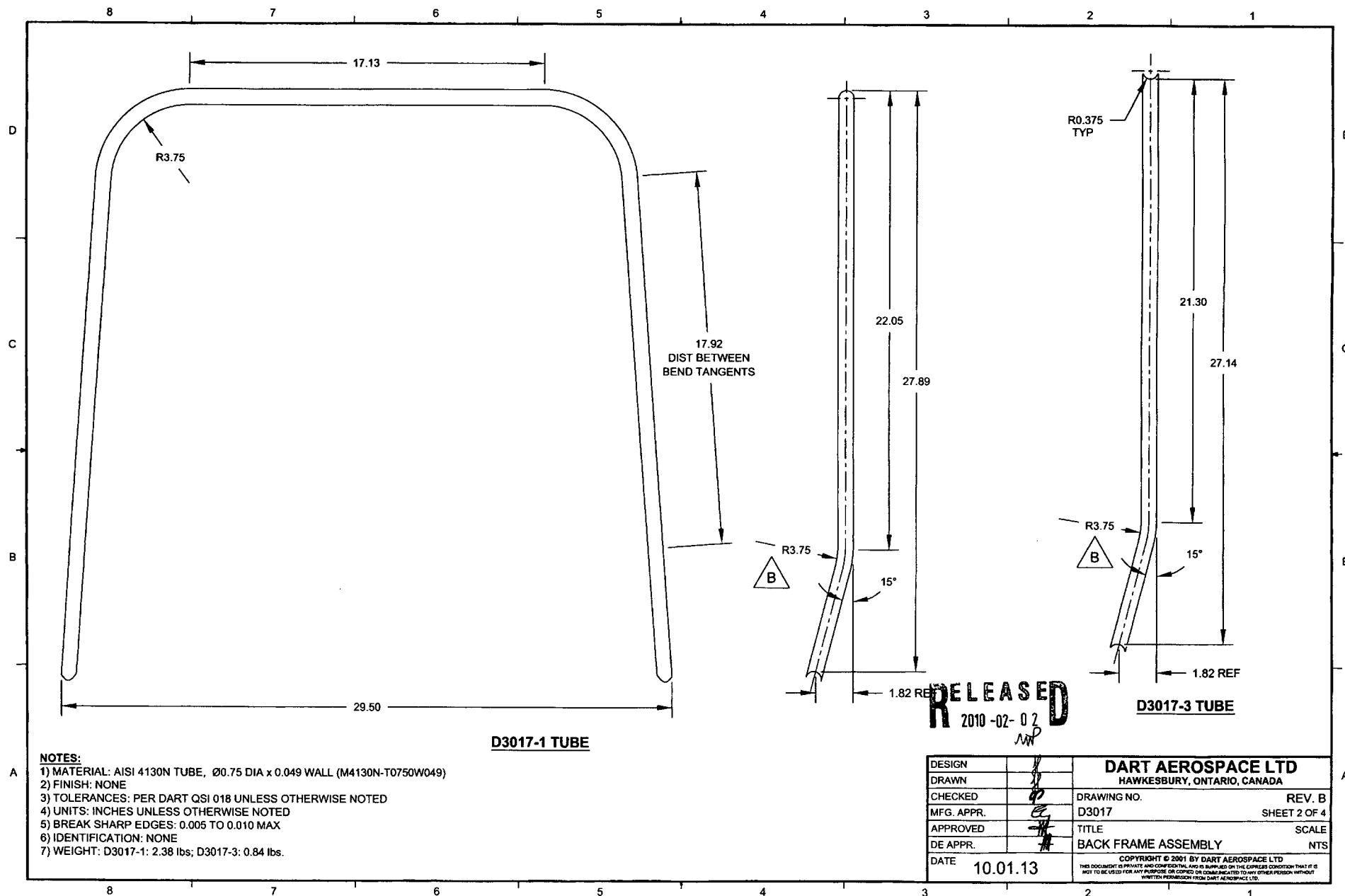
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

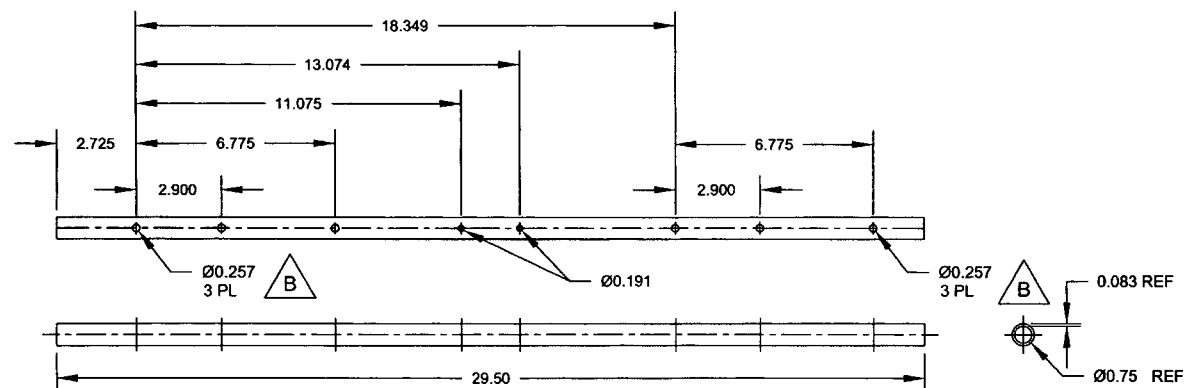
B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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D3017-5 TUBE

RELEASED
2010-02-02
mm

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D3017	SHEET 3 OF 4
APPROVED	<i>H</i>	TITLE	SCALE
DE APPR.	<i>H</i>	BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B

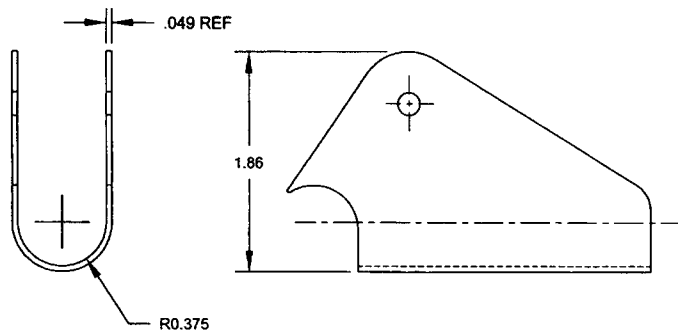
A

D

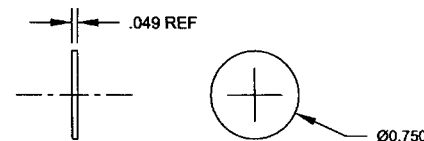
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B

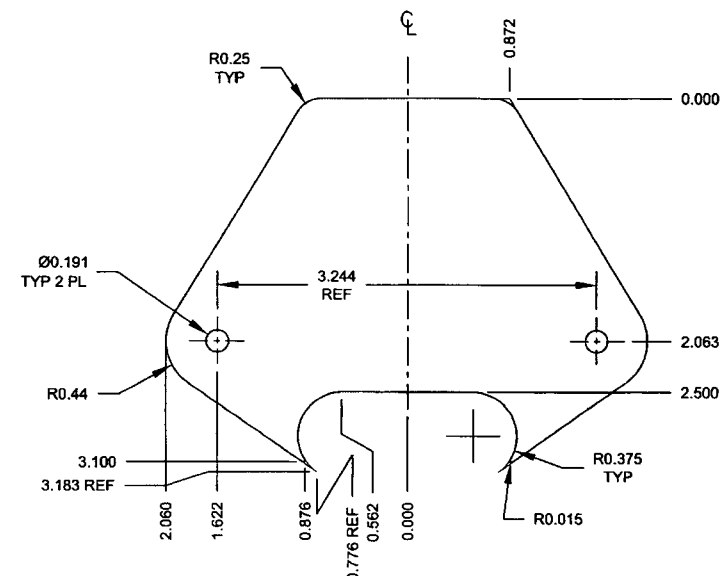
A



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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2010-02-02

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